

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020592**Date Inspected:** 07-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Huang Min and Lil Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 6, 7, 8 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 7

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on OBG deck plate identified as DP3179-001 weld number(s) 045. Welder is identified as welder no. 217185. The welding variables recorded by ZPMC QC identified as Mr. Wu Kewen appeared to comply with applicable WPS(s) WPS-B-T-2233-B-U2-F.

FCAW welding of complete joint penetration weld joint(s) located on OBG deck plate identified as DP3179-001 weld number(s) 048. Welder is identified as welder no. 217185. The welding variables recorded by ZPMC QC identified as Mr. Wu Kewen appeared to comply with applicable WPS(s) WPS-B-T-2233-B-U2-F.

FCAW welding of complete joint penetration weld joint(s) located on OBG deck plate identified as DP3179-001 weld number(s) 051. Welder is identified as welder no. 217185. The welding variables recorded by ZPMC QC identified as Mr. Wu Kewen appeared to comply with applicable WPS(s) WPS-B-T-2233-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of complete joint penetration weld joint(s) located on OBG deck plate identified as DP3181-001 weld number(s) 018. Welder is identified as welder no. 204392. The welding variables recorded by ZPMC QC identified as Mr. Wu Kewen appeared to comply with applicable WPS(s) WPS-B-T-2233-B-U2-F.

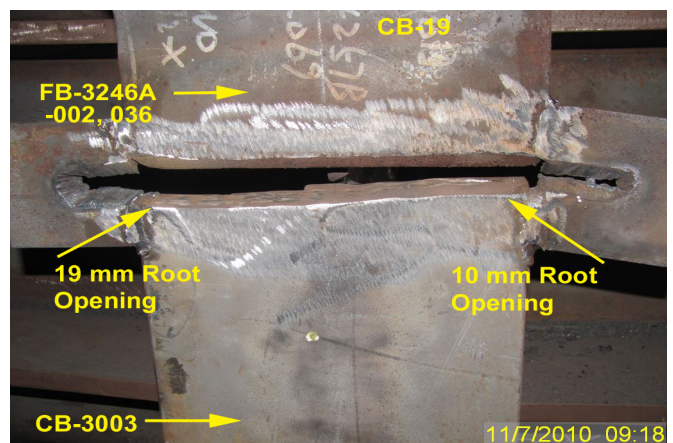
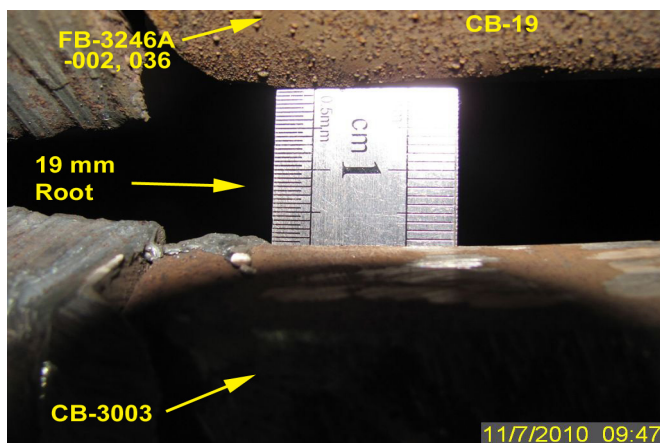
FCAW welding of complete joint penetration weld joint(s) located on Barrier Rails components identified as W2-SB10-031 weld number(s) 019, 050, and 081. Welder is identified as welder no. 062447. The welding variables recorded by ZPMC QC identified as Mr. Shen Jian Guo appeared to comply with applicable WPS(s) WPS-B-T-2231-B-U2-F.

FCAW welding of partial joint penetration weld joint(s) located on Barrier Rails components identified as W2-SB10-031 weld number(s) 097~111. Welder is identified as welder no.062447. The welding variables recorded by ZPMC QC identified as Mr. Shen Jian Guo appeared to comply with applicable WPS(s) WPS-B-T-2333-TC-P4-F and WPS-B-T-2332-TC-P4-F

This QA Inspector observed root openings between 10mm ~ 19mm, weld identified as FB-3246A-001, 036 that did not appear to comply with the contract documents. This QA Inspector informed ZPMC QC identified as Mr. Xu Hai Yang and ABF QA Inspector identified as Mr. Luo Lai Quan of this issue. Mr. Luo informed this QA that the root opening would be corrected in a manner compliant with the contract documents.

Please see the attached photos

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
